

Work Order ID 144416

April 15, 2016 4:00:37 PM

144416

Page 1

Item ID: D4784-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Assembly, Heavy Duty Lid, LH/RH
Start Date: 5/30/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/17/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: SL Date: 20160416 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4784	D								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	0.56							
Hand Finishing	Transfer drill from D4687-210 to label plate as per dwg. Install as per dwg.								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.02							
Quality Control									

DAS
43
9-89 MAY 26 2016

DAS
38
9-89 MAY 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.01							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

Handwritten: PFP 144416

Stamp: DAS 27 9-89 MAY 3 2016

Stamp: MCS MAY 27 2016

Stamp: MCS MAY 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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Picklist Print

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Page 1

Work Order ID: 144416

144416

Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.18 NEW ISSUE DD VERF:JLM IPP
REV:B 13.06.17 as per dwg rev.A DD VERF:JLM IPP REV:C
13.06.17 as per dwg rev.pb1 DD VERF:JLM IPP REV:D 13.06.21
DWG REV.B DD VERF:JFS IPP REV:E 13.12.02 DWG
REV.C DD VERF:JLM IPP REV:F 15.01.19 DWG REV.pd1
DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
97447A010 *97447A010* Blind Rivet		Purchased	No				Each	188.0000		4			DAS 6 9-89
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST589	188							
					m131311	188							
D2530 *D2530* Handle Weldment		Manufactured	No				Each	1.0000		1			DAS 6 9-89
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST379	1							
					140965	1							
D2535 *D2535* Spring		Manufactured	No				Each	71.0000		2			DAS 6 9-89
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST008	46							
					138588	2							
					139657	44							
					ST012a	25							
					143808	25							

MAY 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D2537 Manufactured No

Each 21.0000 2

D2537

Bushing

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST008

21

139004

1

141054

20

Each

0.0000

1

**

D3914-041

Manufactured No

D3914-041

Long Basket Lid Assembly (350)

D3917-3

Manufactured No

Each 93.0000

6

D3917-3

Washer

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST058

93

141536

93

Each

37.0000

2

**

D3953-3

Manufactured No

D3953-3

Gas Spring Stud, Lid

DAS
6
9-89

Location

Loc Qty

Loc Code

ST062

37

138388

2

141606

35

Each

38.0000

2

**

D3953-7

Manufactured No

D3953-7

Spring Spacer

DAS
6
9-89

Location

Loc Qty

Loc Code

ST062

38

138972

38

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Shop Packet Print

MAY 25 2016
Page 2

DQA: _____ Date: _____



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Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

Each 35.0000 2

D3953-9

DAS

Gas Spring Washer

6

9-89

Location

Loc Qty

Loc Code

ST062

35

139013

2

141591

33

Each

43.0000

2

DAS

D3953-17

Manufactured No

D3953-17

Gas Spring Spacer

6

9-89

Location

Loc Qty

Loc Code

ST062

43

141477

25

142705

18

Each

32.0000

1

DAS

D3953-19

Manufactured No

D3953-19

Gas Spring Bracket

6

9-89

Location

Loc Qty

Loc Code

ST062

32

138913

32

Each

24.0000

1

D3953-21

Manufactured No

D3953-21

Gas Spring Bracket

DAS

6

9-89

Location

Loc Qty

Loc Code

ST063

24

139553

6

141546

18

MAY 25 2016

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

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Page 4

Work Order ID: 144416

144416

Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No

Each 16.0000 1

D3969-3

Spring (Basket Lid)

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST365

16

140555

6

141701

10

D4785-041 Manufactured No

Each 0.0000 1

D4785-041

Long Basket Base Assembly, LH/RH

D4786-210

Manufactured No

Each 2.0000 1

D4786-210

Placard, Max Load

**

**

MAY 25 2016

13144417 (12/2016) 16/16/12

145258

DAS

6

9-89

Location

Loc Qty

Loc Code

ST126

2

128577

2

AN3-14A Purchased No

Each 97.0000 4

AN3-14A

Bolt

**

Location

Loc Qty

Loc Code

over003

80

m133992

50

m134360

30

ST349

17

m134167

17

DAS

6

9-89

MAY 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Work Order ID: 144416

144416

Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-16A	Purchased	No	Each	88.0000	2	DAS
AN3-16A						6
Bolt						9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
			GA	45		
			117441	45		
			ST348	43		
			M133790	43		2
AN310C4	Purchased	No		Each	82.0000	2
AN310C4						DAS
Nut						6
						9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
			OVER007	30		
			M134370	30		
			ST331	52		
			M133694	2		
			M133990	50		2
AN310-4	Purchased	No		Each	108.0000	3
AN310-4						DAS
Nut						6
						9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
			GA	25		
			M127815	25		
			OVER007	75		
			M133990	25		
			M134180	50		3
			ST331	8		
			M133790	8		

MAY 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Page 6

Work Order ID: 144416

144416

Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No

Each 89.0000 3

AN4-12

DAS
6
9-89

Bolt

Location

Loc Qty

Loc Code

ST344

89

m133988

49

m134370

40

3

AN5-17A Purchased No

Each 147.0000 4

AN5-17A

DAS
6
9-89

Bolt

Location

Loc Qty

Loc Code

GA

33

117872

33

over003

75

m134606

75

ST337

39

m134055

39

4

MS21042L3 Purchased No

Each 1,784.000 6

MS21042L3

DAS
6
9-89

Nut

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

786

m133790

3

m134360

783

ST304

898

m134039

12

m134360

886

134634

MAY 25 2016

April 15, 2016 4:00:37 PM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER : _____																																																																				

Picklist Print

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Work Order ID: 144416

144416

Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

Each

521.0000

4

MS21042L5

Nut

Location

Loc Qty

Loc Code

GA

133

m127813

133

OVER007

100

m134509

100

ST303

288

m134055

38

m134567

250

MS24665-151

Purchased

No

Each

170.0000

4

MS24665-151

Cotter Pin

Location

Loc Qty

Loc Code

GA

64

m128401

64

ST289

106

m133769

6

m134294

100

MS24665-300

Purchased

No

Each

47.0000

2

MS24665-300

COTTER PIN

Location

Loc Qty

Loc Code

GA

30

118234

30

ST288

17

M128812

17

DAS
6
9-30

DAS
6
9-30

DAS
6
9-30

134738

MAY 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Work Order ID: 144416

144416

Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

Each

1,915.000

8

NAS1149F0332P

Washer

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

312

m133709

312

ST262

1603

m134134

103

m134257

1500

Each

1,223.000

2

NAS1149C0432R

Purchased

No

NAS1149C0432R

WASHER

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

498

m125807

428

m133790

70

ST266

725

m134073

725

Each

1,495.000

6

NAS1149F0432P

Purchased

No

NAS1149F0432P

WASHER

DAS

6

9-89

Location

Loc Qty

Loc Code

ST260a

1000

M134502

1000

ST262

374

M133990

374

st268

121

M132677

121

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

Picklist Print

April 15, 2016 4:00:37 PM

Page 9

Work Order ID: 144416

144416

Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 5/30/2016

Required Date: 6/17/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P

Purchased

No

Each

114.0000

4

NAS1149F0563P

DAS

Washer

6

9-80

Location

Loc Qty

Loc Code

ST261

114

m133515

114

9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

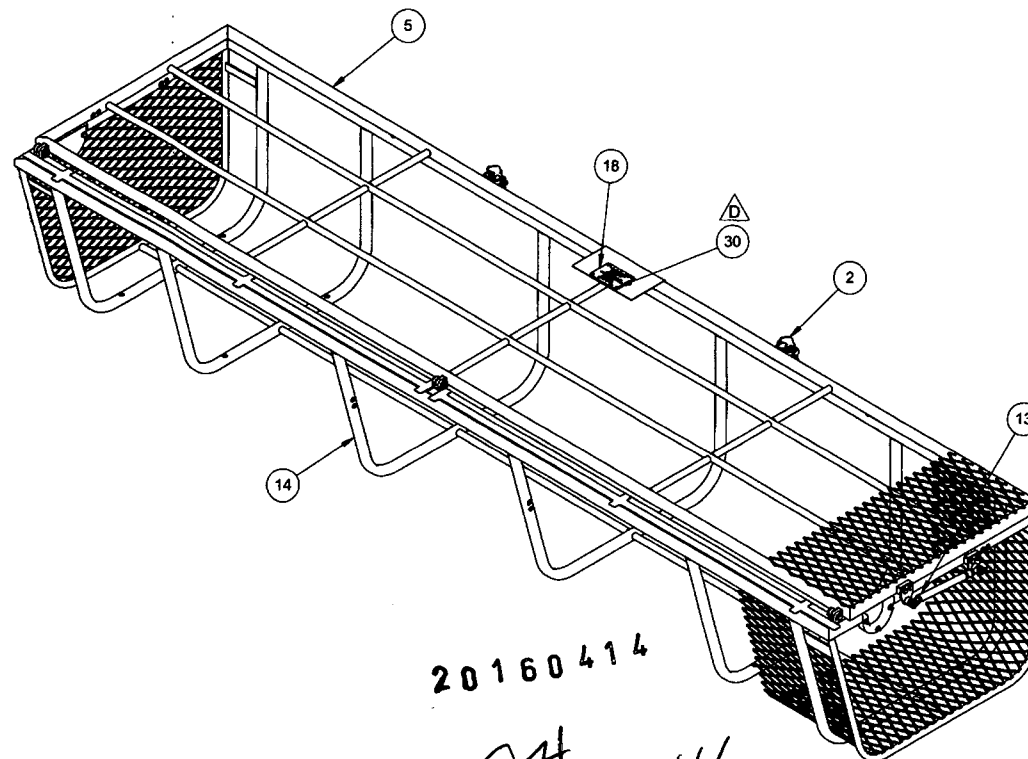
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4784-011	BASKET ASSY, HEAVY DUTY LID, LH/RH
2	1	D2530	HANDLE WELDMENT
3	2	D2535	SPRING
4	2	D2537	BUSHING
5	1	D3914-041	LONG BASKET LID ASSY (350)
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	1	D4785-041	LONG BASKET BASE ASSY, LH/RH
18	1	D4786-210	PLACARD, MAX LOAD
16	4	AN3-14A	BOLT
17	2	AN3-16A	BOLT
18	2	AN310C4	NUT, CASTELLATED
19	3	AN310-4	NUT, CASTELLATED
20	3	AN4-12	BOLT
21	4	AN5-17A	BOLT
22	6	MS21042L3	NUT, SELF-LOCKING
23	4	MS21042L5	NUT, SELF-LOCKING
24	3	MS24665-151	COTTER PIN
25	2	MS24665-300	COTTER PIN
26	8	NAS1149F0332P	WASHER
27	2	NAS1149C0432R	WASHER
28	6	NAS1149F0432P	WASHER
29	4	NAS1149F0563P	WASHER
30	4	97447A010	BLIND RIVET, PAN HEAD

△



D4784-011 BASKET ASSEMBLY HEAVY DUTY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED

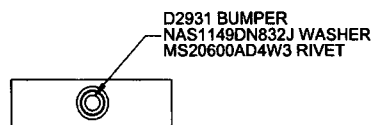
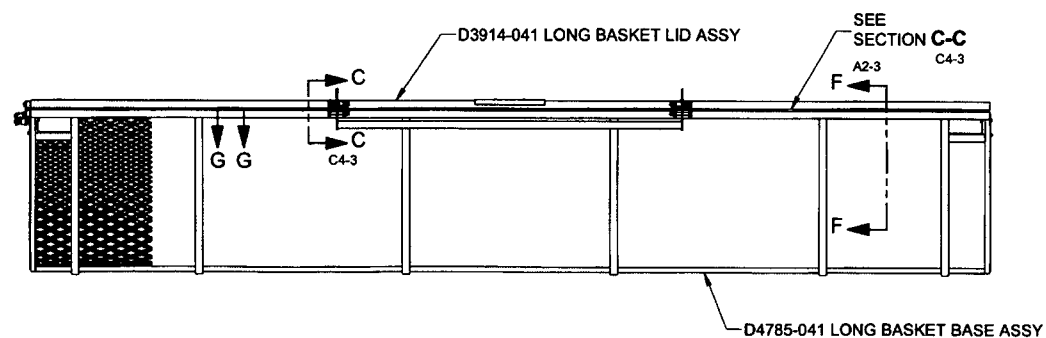
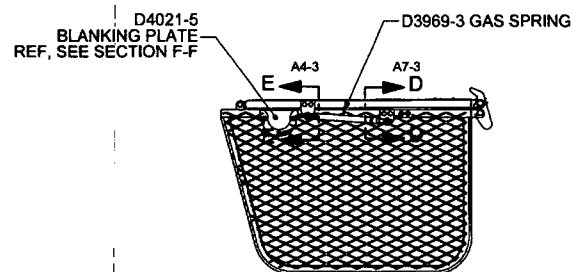
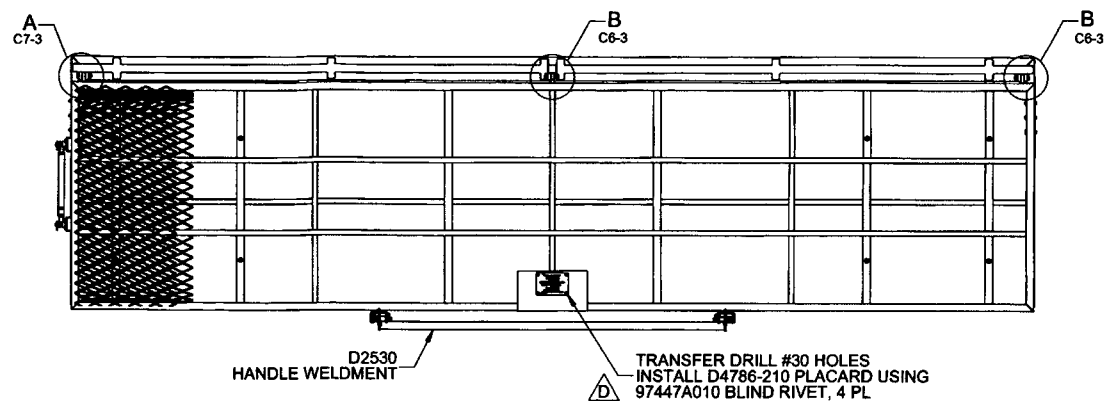
2015 MAR 16
ECN 15-F30

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 80.10 lbs

D	ADDED 97447A010 (ZN B6-1 & C3-2)	RF	15.01.13
C	REVISE D3969-3 QTY (ZN C8-1); REF PAR13-315	RF	13.11.25
B	REVISE D4785-041 SHOWN	RF	13.06.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4784	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET ASSEMBLY	NTS
DATE	15.01.13	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



SECTION G-G
(LID ASSY REMOVED FOR CLARITY)

D4784-011 BASKET ASSEMBLY HEAVY DUTY, LH/RH
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

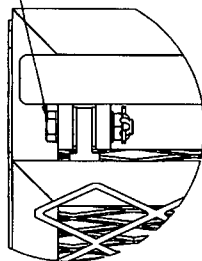
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2015 MAR 16

APPROVED

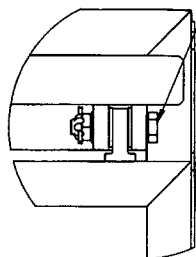
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4784	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET ASSEMBLY	NTS
DATE	15.01.13	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



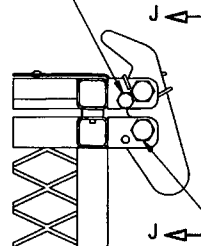
DETAIL A D6-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



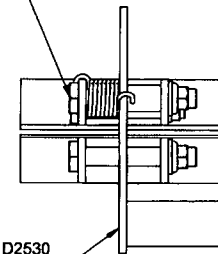
DETAIL B D2-2
D4-2

AN3-16A
MS21042L3 NUT



SECTION C-C B5-2
B3-2

AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW J-J

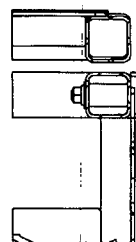
D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3969-3 GAS SPRING
REF

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

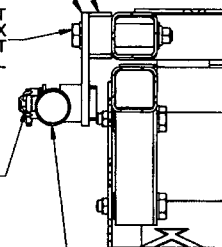


SECTION D-D B7-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

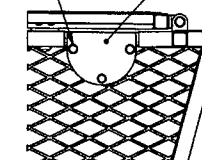
D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN



SECTION E-E B7-2

D3969-3 GAS SPRING
REF

AN3-10A BOLT
NAS1149F0332P WASHER
MS21042L3 NUT
3 PL, REF



D4021-5
BLANKING PLATE
REF

SECTION F-F B2-2

RELEASED

2015 MAR 16

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4784	SHEET 3 OF 3
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